

Work Order ID 57031

March 17, 2010 1:13:39 PM

Page 1

Item ID: D212-580-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Cargo Mirror Assembly

Start Date: 17/03/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 22/03/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: M Date: 10-3-17 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2161	Rev B2

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-580-041 CHG003

Solobay

110 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg D2161 Identify as D2161-212 A/R SS ROD Batch: M162421*BZ 10-3-30*

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

*Solobay**(X4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

④ PD 10.03.31

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:45pm

OVEN TEMPERATURE:

12:15pm FINISH TIME:

320°F

=) JH 10/04/07

4 d

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JH 10-4-7

④ d

Dart Aerospace Ltd

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-4-19

42

SP

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/04/21

A

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-580-041

Location: 22

PPP Rev: 4

10-4-21

SP (42)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/21 *[Signature]*

MF 10-4-21

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NOTE: Date & initial all entries

Picklist Print

March 17, 2010 1:13:43 PM

Page 1

3

Work Order ID: 57031

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 17/03/2010

Required Date: 22/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08

44

Purchased

No

100

Each

2,161.000

16.0000



Screw

10-4-168

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST291

2161

110467

3

110552

158

110835

2000

D2013-3

Manufactured

No

110

Each

4.0000

4.0000



Mirror Bracket LH, 212

16

10-3-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

4

52274

4

D2013-4

Manufactured

No

110

Each

4.0000

4.0000



Mirror Bracket RH, 212

4

10-3-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

4

52275

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 57031

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 17/03/2010

Required Date: 22/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

GCR264SS3-2

44

Purchased

No

170

Each

214.0000

16.0000



Rivet, Cherry

10-4-195

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

214

108688

6

108738

108

112314

100

4x
10

D2011-103

42

Manufactured

No

170

Each

23.0000

8.0000



8" Mirror

10-4-195

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST226

23

52198

23

8

D2037-101

Manufactured

No

170

Each

15.0000

4.0000



Arm

10-3-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

41854

1

52272

14

4

March 17, 2010 1:13:44 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

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Parent Item Name: Cargo Mirror Assembly

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 17/03/2010

Required Date: 22/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21059L3 Nut Plate		Purchased	No			170	Each	47.0000	8.0000			



M114449 10-4-215 (4)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST302

47

109962

11

111925

8

113749

28

March 17, 2010 1:13:44 PM

Shop Packet Print

Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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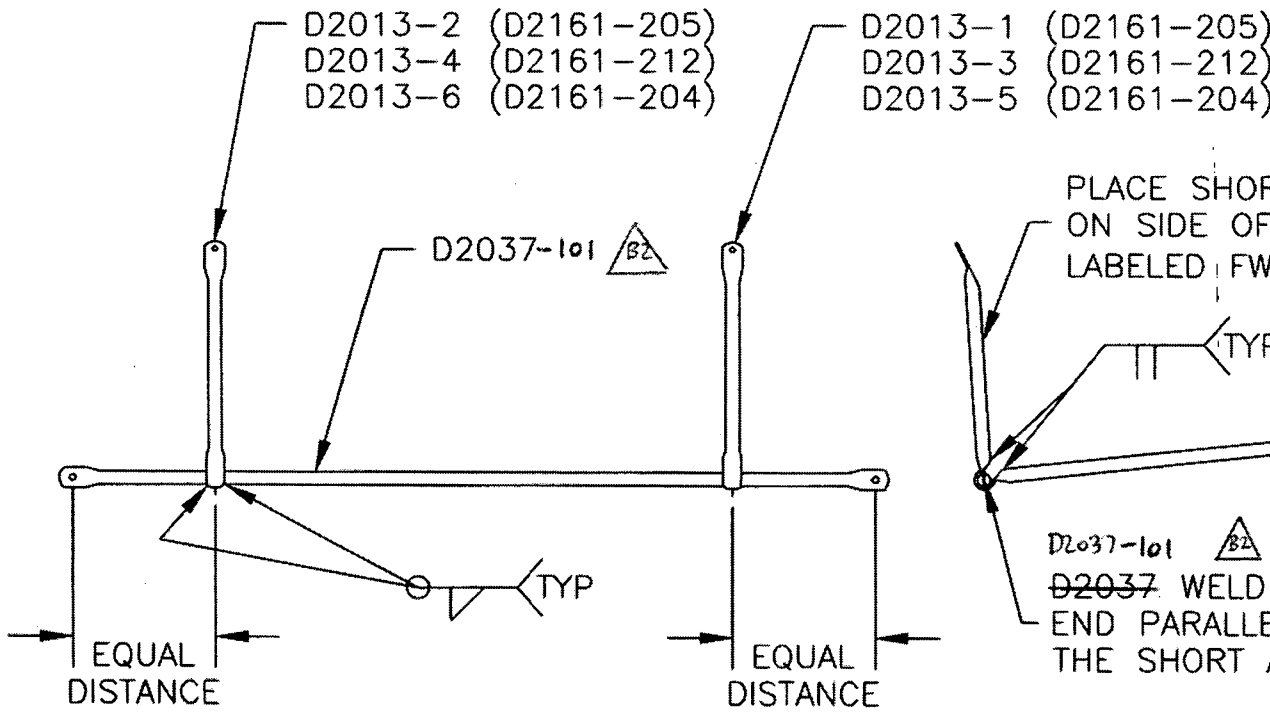
NOTE: Date & initial all entries

SHORT COPY

RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57031

240-3-17

DART



D2037-101 $\triangle B2$
D2037 WELD FLAT
END PARALLEL TO
THE SHORT ARM

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 $\triangle B1$

DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA
CHECKED	<i>KE</i>	APPROVED	
DATE	99.06.07	TITLE	MIRROR BRACKET
A		93.04.29	NEW ISSUE
B		99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	<i>KE</i>	02.03.25	CHANGE FINISH
B2	<i>KE</i>	02.06.14	D2037-101 WELD

RELEASED
KE 99.06.10

W/O:		WORK ORDER CHANGES					
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D204-562-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kG
D205-563-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kG
D212-580-041	5.0 lb	0 in	0 lb-in	-5.25 in	-26.3 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	-0.13 m	-0.30 m-kG

5.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D2011-103	MIRROR
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		4	CCR264SS-3-2	RIVET, BLIND
		2	MS21059L3	NUTPLATE
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D2011-103 MIRROR

W/O:		WORK ORDER CHANGES					
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